

Date: Monday, 3/13/2006 7:30:24 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP SPACER	
Job Number	: 26211D		Part Number	: D30657	
Estimate Number	: 10380		Drawing Number	: D3065 REV. A2	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/13/2006 S.O. No. : N/A		Drawing Revision	: A2	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/30/2006	
Previous Run	: 24408D		Qty:	60 Um: Each	
Written By	: See comment below				
Checked & Approved By	: 98/06.03.13 N				
Comment	: Est:C 02.11.01 Incorporated D3066-1 IPP KJ/RF				

Additional Product

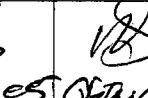
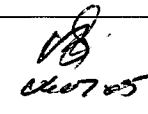
Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		<p>Comment: Qty.: 0.1653 sf(s)/Unit. Total : 9.9162 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.040" thick (M2024T3S.040) Batch: M19295 M19295 06/05/05 SAD 06/05/16</p>
2.0	SHEAR	SHEAR
		<p>Comment: SHEAR Cut blank: 4.580" x 4.500" Grain along 4.500"</p>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
		<p>Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA181 and Dwg D3065 Stack of 15 Identify as D3065-7</p> <p>Water Jet Dwg Rev <u>A2</u> Prog Rev <u>A2</u></p>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p> <p><i>ml 06/05/16</i></p>
5.0	QC8	SECOND CHECK
		<p>Comment: SECOND CHECK</p> <p><i>JG 06/05/17</i></p>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 0607/06
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0607/05	7	1 part are map		Scrap & Destroy	SB 0607/05			

NOTE: Date & initial all entries

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: STEP SPACER
Job Number: 26211D		Part Number: D30657
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack		M.F. 06-05-24- (60) SAD 06/05/16 60
7.0	BRAKE NC 	NC BRAKE 
Comment: NC BRAKE Bend as per Dwg D3065		SB 06/06/03 (60)
8.0	QC5 	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		Job 06-06-05 (60)
9.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		H.M 06-06-15 (60)
10.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT CHEMICAL CONVERSION COAT		SAD 06/07/05 60
11.0	PACKAGING 1 	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA		SB 06/07/05 (60)
12.0	DC 	DOCUMENT CONTROL 
Comment: DOCUMENT CONTROL Inspection Level 21		(D) 06/07/06 (60)
Job Completion 		U 06.07.05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3065-5DART AEROSPACE LTD	Work Order:	26211D
Description: Step Spacer	Part Number:	D3065-7
Inspection Dwg: D3065	Rev: A2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD/Jeff	Audited by:	J	Prototype Approval:	N/A
Date:	06-09-16	Date:	06-05-17	Date:	N/A

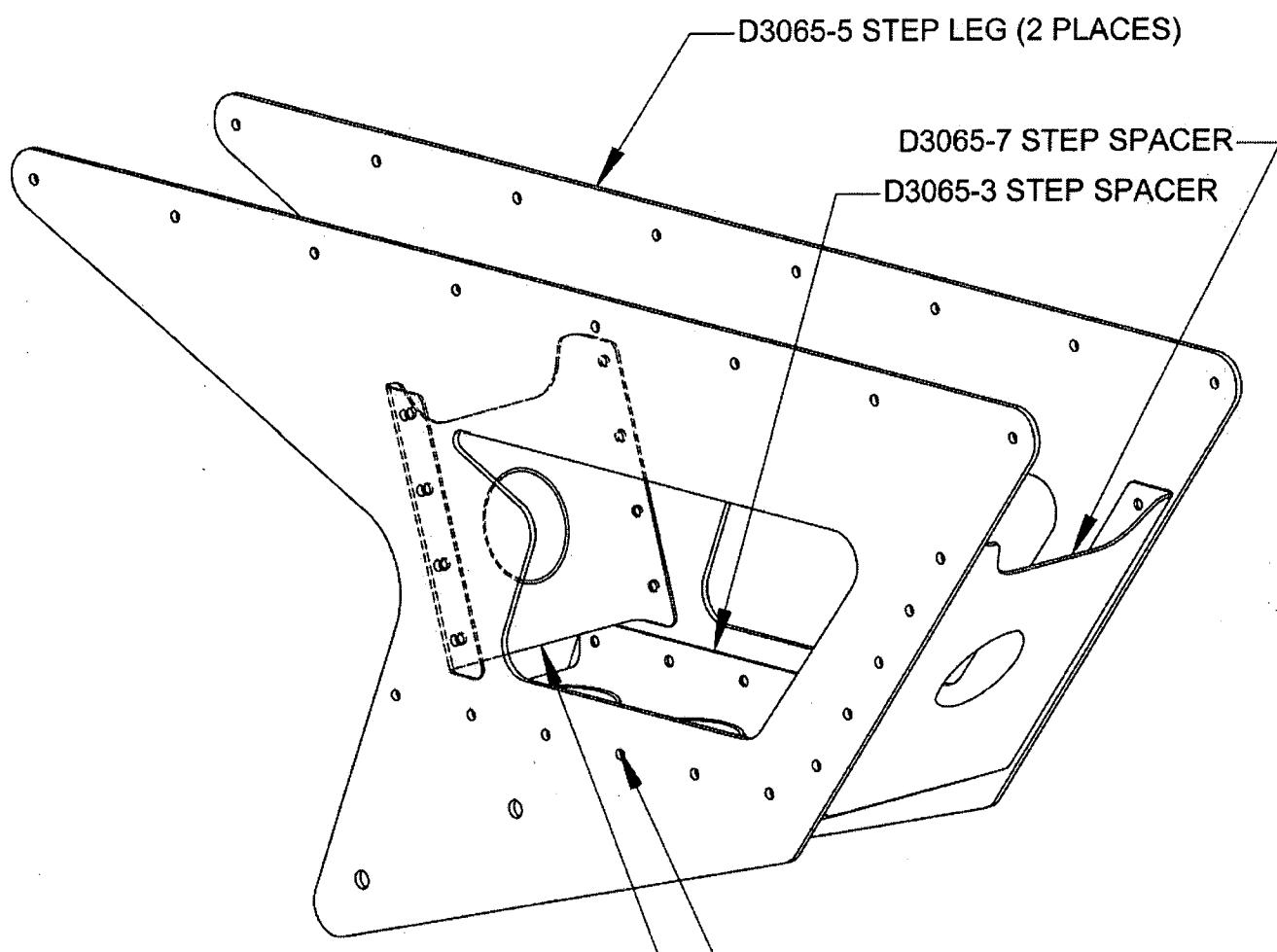
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.05.15	Removed 0.531, 3.686, 0.580; Added 3.936 dimensions	KJ/JLM	<i>[Signature]</i>



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DATE	02.09.11	TITLE STEP LEG ASSEMBLY SHEET 1 OF 5 SCALE 1:2

RELEASED
02.09.20

A	02.09.11	NEW ISSUE
A1	03.02.13 (P)	ADD SLOTS TO D3065-5
A2	03.02.27 (P)	0.551 WAS 0.410



D3065-041 STEP LEG ASSEMBLY

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WORK ORDER
NO 26211D

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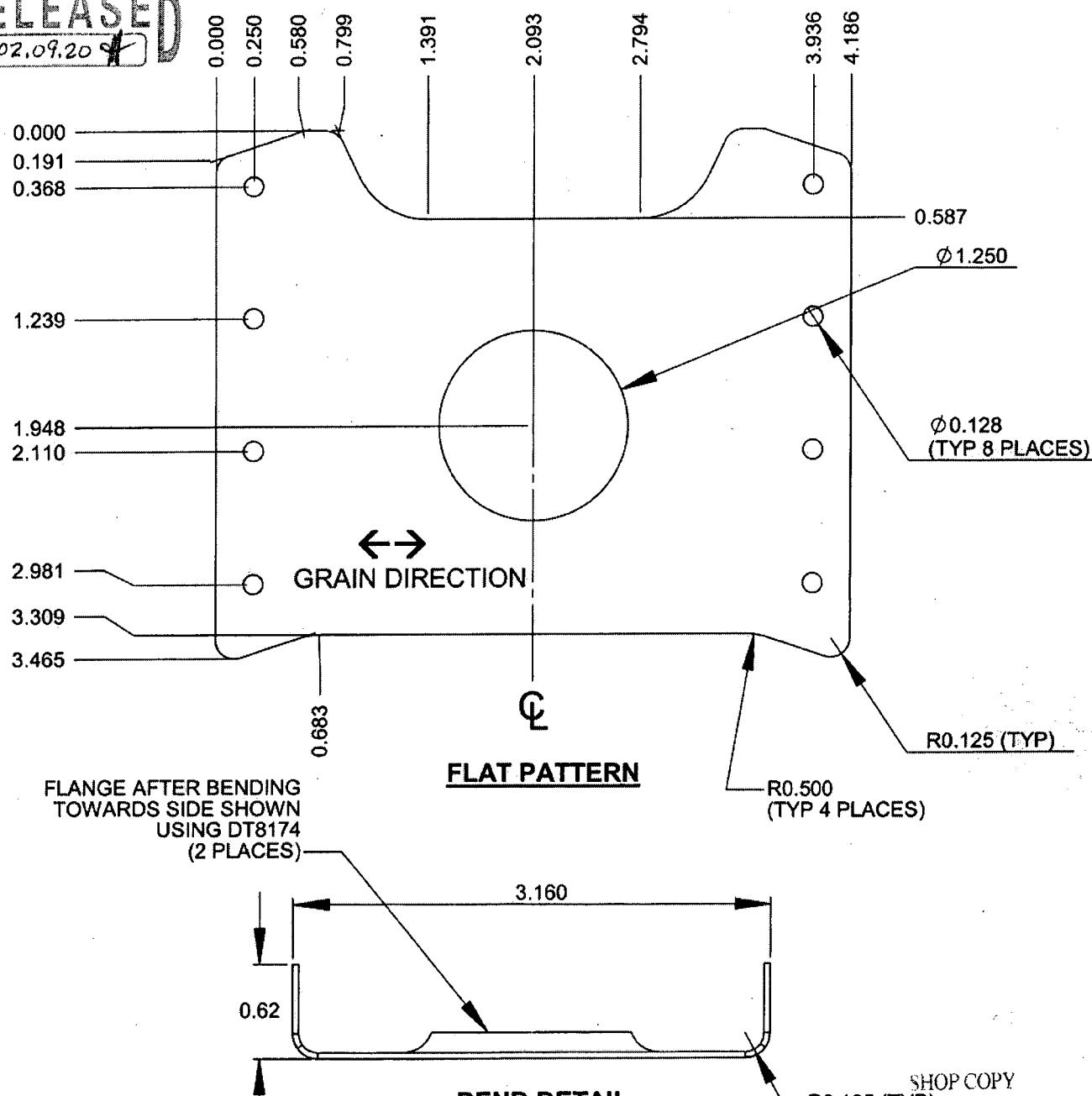
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DATE	02.09.11	TITLE	STEP LEG ASSEMBLY

SHEET 2 OF 5

SCALE
1:1

RELEASED
02.09.20



D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S-040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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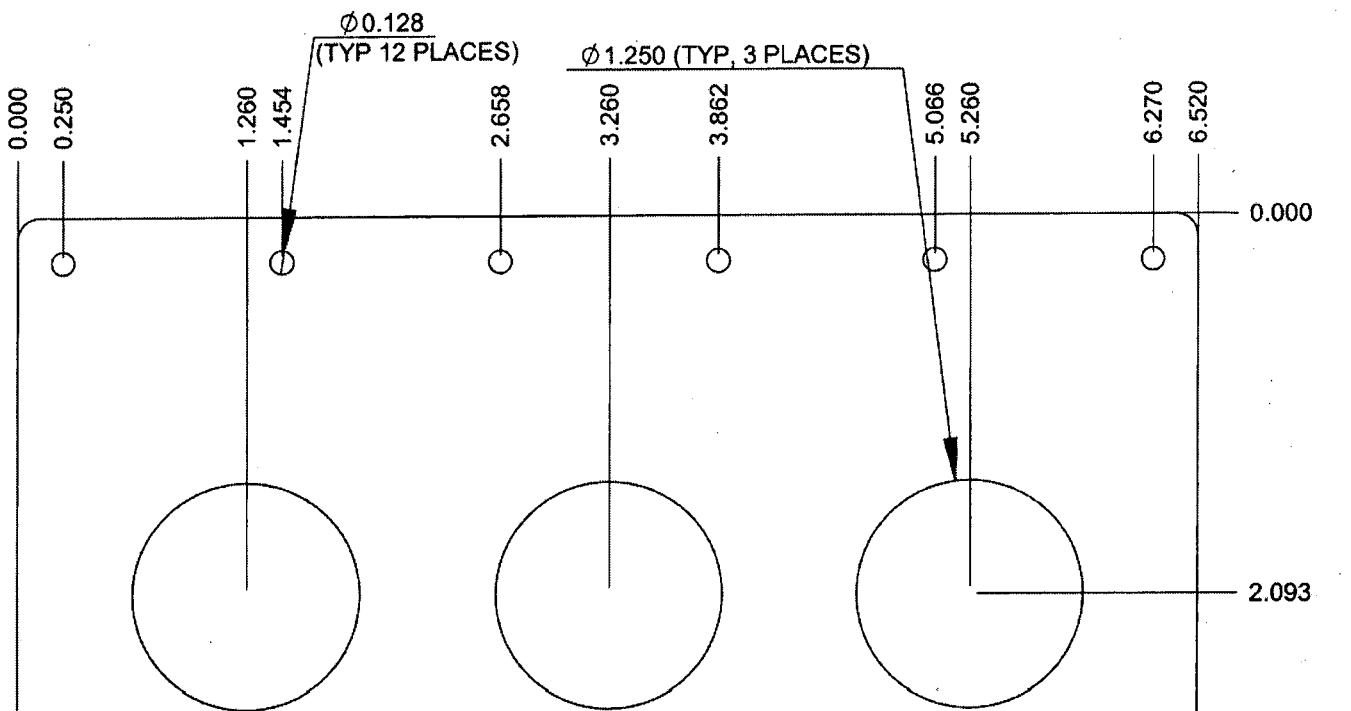
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02.09.20 

02.09.20 4



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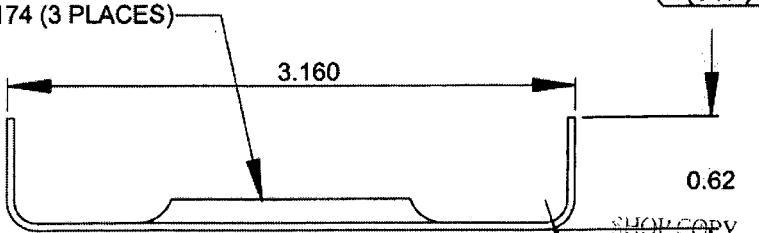
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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3065	REV. A	SHEET 3 OF 5
DATE 02.09.11	TITLE STEP LEG ASSEMBLY	SCALE 1:1		



FLAT PATTERN

GRAIN DIRECTION

FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)



D3065-3 STEP SPACER

BEND DETAIL

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BEND DETAIL

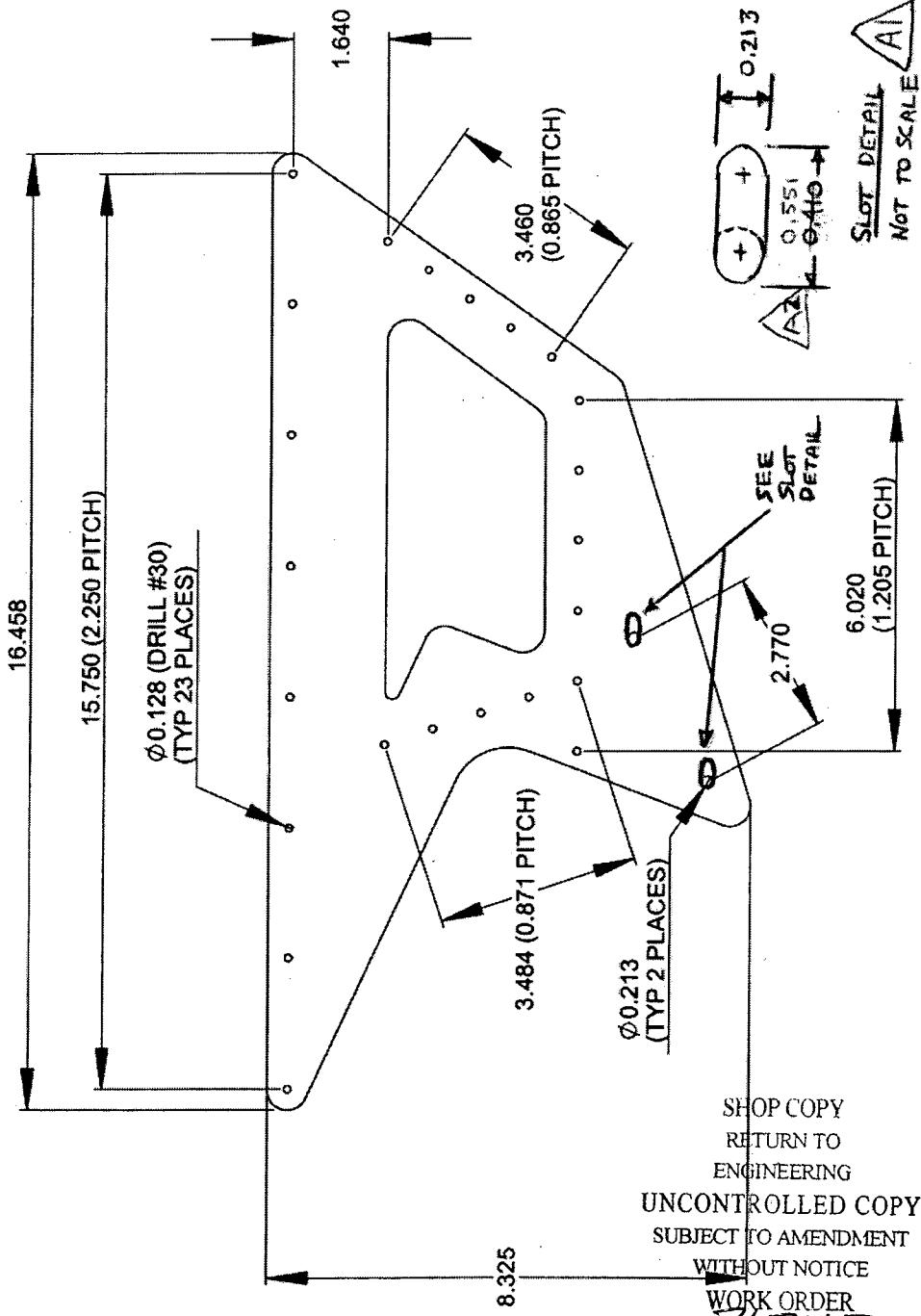
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CHECKED	APPROVED	DRAWING NO. D3065
DATE	02.09.11	TITLE STEP LEG ASSEMBLY

REV. A
SHEET 4 OF 5SCALE
1:3**RELEASED**
(02.09.20)**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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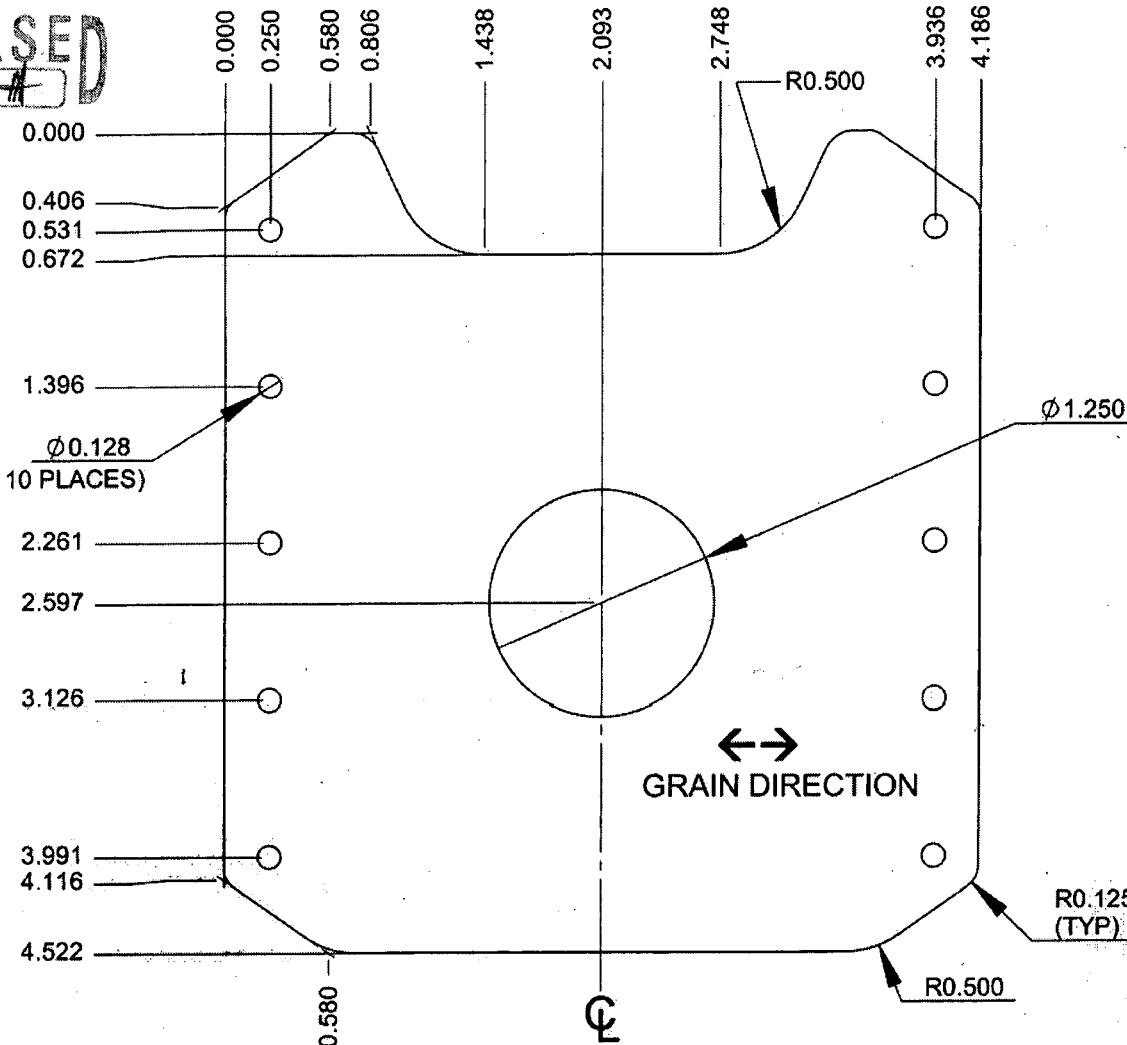


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		D3065	SHEET 5 OF 5

DATE 02.09.11 TITLE STEP LEG ASSEMBLY SCALE 1:1

RELEASED
02.09.2011



FLANGE AFTER BENDING TOWARDS
SIDE SHOWN USING DT8174 (2 PLACES)

FLAT PATTERN

BEND DETAIL

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WORK ORDER
NO. 26211 D

D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S040) TROLLED COPY
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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